											DQA:	Date:	•
NCR:	Yes	/ No	•	OA Classed	Data	¢							
											QA Closed:	Date	:
Work Ord	er:					DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part I	٠ . No					Rework Scrap Use-as-is Work Order Update	f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date Step Qty or Non-conformance						nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						, `							
		 					AUI	LT CATE	<u> </u>				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped. it n Strip in		O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		4	ion Incomplete ions Incomplete/l enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
l	1 1	Ripples in	pena			וויוטופג חטופג	1	Jouset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	Work Orde				*916		Page 2				
	Revision ID:	D407-581-			Accept	*N900	N4N10) () *	Setup Start	14.71	
¥	Start Date: Required Date: Reference:	10/11/12 11/02/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:					
	Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		Run Start Stop	"NR1"	
	Sequence ID/ Work Center II 130 *130* Packaging Packaging	D	Operation Description Packaging Memo Identify and Location: PPP Rev:	pack for shipping as per	Set Up/ Run Hours 0.00 0.00 PPP D407-581-111	Tool ID	Tool # Pla Coo	le Qty	Qty	Reject Insp. Number Stamp	
**	140 *140* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00			Zuc	el ec		

									DQA:	Date:	· 5
NCR: Ye	s / No				WORK ORDER NON-C	CONFORM	QA Closed:	Date:	•		
Work Order	•				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
Part No).				Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data											
quip/Tooling											
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etup											
Other											
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upplier			1						1		

Landing Gear General Bending Bend Grain Ovalized Pressure/Forced BOM/Route Temperature/Cure Centre Not Concentric to O/S Hardware Over/Under tolerance Broken/Damaged Inspection Incomplete Weld Cracks Part Incorrect Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Mislabeled Positioned Wrong Countersink Inspection Strip in Tube Power Loss/Surge Other Cut Too Short Misread Ripples in Bend Drill Holes Offset **Torque Waves in Extrusion** Drawing Out of Calibration **Turning Sequence** Out of Sequence Finish

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Training Unapproved

. October-18-12 9:55:25 AM

Work Order ID:

91648

Parent Item:

D407-581-111

Parent Item Name:

Pre-Flight Installation

Start Date: 10/11/12

Required Date: 11/02/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

Ipp Rev:A New Issue 10-07-16 JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D¥07-581-011 Pre-Flight Step Installation	, LH/RH	Manufactured	No			100	Each	2.0000	2	, . 2	54)	8
STAR STAR				Location FG031		Loc Qty	Lo	c Code				1	
D206-581-015)		Manufactured	No	885	45	$\sqrt{100}$	Mack	2 () () () () () () () () () (<u>)</u>	. \ \		0
Step Handle Installation		Manufactured		I4'		U	I.				- (3/10/E	آ ڪڙ	>4-
of the said				Location FG031		Loc Qty 4	<u>Lo</u>	c Code	_			~ &	
				829 874		2	<u>!</u> !		<u> </u>	<u> </u>			

11 D206.581-113

											DQA:	Date	:
NCR:	Yes	/ No			1 5	WORK ORDER NON-C	100	NFORM	MANCE / UPI	DATE			
	·								*		QA Closed:	Date	: 3
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT		
Work Ora	٠,٠,		······································			Rework	1	Skid-tube Crosstube			İ	Water Jet	Engineering
Part f	No.					Scrap		ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data		340	0.07	~.,						<u> </u>			
Equip/Tooling					•						<u> </u>		
Operator	П						ļ						
Material													
Setup													
Other													
Process									:				
Supplier					,		Ì						
Training				į.				:					
Unapproved						• • •							
						F/	AUL	T CATE	GORY				
Landi		1			_	General	_	,			1		
	<u> </u>	Bending				Bend	<u> </u>	Grain			Ovalized		Pressure/Forced
	<u></u>	Centre Not Concentric to O/S				BOM/Route	_	Hardwa		_	Over/Under	 	Temperature/Cure
		Cracks				Broken/Damaged	<u></u>	3	on Incomplete		Part Incorre		Weld
	<u> </u>	Crushed/	Crimped		_	Burrs	<u>_</u>	•	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte			Part Moved		
	Heat Treat					Countersink	\vdash	Mislabe		<u></u>	Positioned V	_	\neg
	-	Inspection	•	Tube		Cut Too Short		Misread	i		Power Loss/	'Surge	Other
	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Ripples in				Drill Holes		Offset					
	l	Torque W	/aves in E	xtrusio	n	Drawing	1	Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

DART AEROSPACE LTD.

REFERENCE ONLY



D206-581 Page 17 of 18

5.0 **PART LIST**

D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS 5.1

Qty_ \-111	Qty]-113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description			
Х							D407-581-111	PRE-FLIGHT KIT (407)			
	Х						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)			
æ2 -		X	-	-			_D407=581-011	= PRE-FLIGHT_STEP_KIT, LH/RH (407)			
	1		Х				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)			
	-1			Х			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)			
-4-	4			toneral contractors	X		-D206-581-015	STEP HANDLE KIT			
						Х	D206-581-017	RETENTION STRAP KIT			
						2	D3031-3	LOOP			
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY			
			1				D4102-1	SHIM (206 LH)			
				1			D4102-2	SHIM (206 RH)			
		1					D4102-3	SHIM (407)			
					1		D4103-1	STEP HANDLE			
						1	D4104-041	DOUBLER ASSEMBLY			
						1	D4105-1	STRAP			
						2	80-004-2D8	INSERT			
					2		80-005-3-8	INSERT			
		6	6	6			80-005-3-16	INSERT			
						8	CR3243-4-1	RIVET			
						2	MS21042L3	NUT			
						2	MS24694-S47	SCREW			
						2	MS24694-S50	SCREW			
						2	MS24694-S52	SCREW			
					2		MS27039-4-11	SCREW			
		6	6	6			MS27039-4-14	SCREW			
						2	NAS1149D0332J	WASHER (or AN960JD10L)			
		6	6	6	2		NAS1149D0416J	WASHER (or AN960JD416L)			
					2		NAS1149D0463J	WASHER (or AN960JD416)			
					<u> </u>						

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Revision: C

Date: 10.07.10

5.0 **PART LIST**

D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS 5.1

Qty. (111)	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	Х						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
~2_		_x_					_D407_581-011=	= PRE-FLIGHT-STEP_KIT, LH/RH (407)
	1		Х				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	-1			X			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
F4==	==4				X=		D206-581-015	-STEP HANDLE KIT-
						X	D206-581-017	RETENTION STRAP KIT
					·		,	
						2	D3031-3	LOOP
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY
			1				D4102-1	SHIM (206 LH)
				1 D4102-2	D4102-2	SHIM (206 RH)		
		1					D4102-3	SHIM (407)
			\		1		D4103-1	STEP HANDLE
		<u> </u>				1	D4104-041	DOUBLER ASSEMBLY
		 				1	D4105-1	STRAP
<u> </u>								
						2	80-004-2D8	INSERT
				1	2		80-005-3-8	INSERT
		6	6	6			80-005-3-16	INSERT
	·					8	CR3243-4-1	RIVET
						2	MS21042L3	NUT
	÷					2	MS24694-S47	SCREW
		1				2	MS24694-S50	SCREW
				† · · · · · · ·		2	MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
		6	6	6			MS27039-4-14	SCREW
	 	 		1		2	NAS1149D0332J	WASHER (or AN960JD10L)
	 	6	6	6	2	T	NAS1149D0416J	WASHER (or AN960JD416L)
			2		NAS1149D0463J	WASHER (or AN960JD416)		
						1		

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Revision: C

Date: 10.07.10

October-18-12 9:55:25 AM

Item ID:

Required Date: 11/02/12

Accept D407-581-111

Stop

Revision ID: Item Name:

Pre-Flight Installation

Start Date:

10/11/12

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date/210-10

Tooling:

Start Run

Stop

Reject

MC2 15-10.50

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Insp. Number Stamp

Revision Nbr Draw Nbr C D206-581

100

100 DC

Document Control

DOCUMENT CONTROL (105)

Memo

0.00

0.00

Photocopy bluefile & type labels per PPPD407-581-111

CHG001

110

110

Packaging Packaging

Pick Kit

Memo

0.00

0.00

QC4-100% Inspect kits for completeness

0.00

120

QC

120

Memo

0.00

Quality Control

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																
						41				-	QA Closed:	Date:				
Work Ord	er:					DISPOSITION	_	AGAINST DEPARTMENT/PROCESS								
Part f		··		0		Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Pro	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR I	No.					Work Order Update	J		Large Fab	Composite		Supplier				
Root					Descri	ption of work order update	П	Initial	Ac	tion	Sign &					
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved																
			•	.	•	F	AUI	LT CATE	GORY							
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	Г	Turning S				Finish		-	Sequence							

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Finish Folio